

Date: Wednesday, 08/10/2008 2:00:19 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 42513 <i>2</i>		Part Number	: D33191	
Estimate Number	: 10437		Drawing Number	: D3319 REV. B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 08/10/2008	S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 25/10/2008	
Previous Run	: 41938		Qty:	12	Um: Each
Written By	:		(2)		
Checked & Approved By	: <i>JUL 08. 10.08</i>				
Comment	: Est: B 05.10.14 Added step 9, dwg rev B		KJ/EC		
	Est Rev:C Now on Waterjet 06-10-26 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M1010S18GA	1010/1025 SHEET .048  14
		Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: <i>10/10/08</i> <i>FB 8-10-16</i>
2.0	WATER JET <i>10/10/08</i>	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: <i>B</i> <i>FB 8-10-16</i> <i>60</i> Prog Rev: <i>B</i>
		2-Deburr if necessary <i>FB 8-10-16</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>FB 8-10-16</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<i>S 08/10/17 (620) complete</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <i>1/A Done cut step #2-2</i> <i>8-10-17</i>

Ship today 21/10

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42513

Part Number: D33191

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B  
2- Form flat on press using DT8776 block

Sp 08/10/20

(3)

7.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK



Sp 08/10/20 (3)

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3  
2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

(X)

Qty Part Number Description Batch  
A/R N/A 7560 Hardcoat Rod M107553

EC 8-10-20

9.0 QC10

VISUAL INSPECTION OF GROUND WELDS



08/10/21



(X3)

Comment: VISUAL INSPECTION OF GROUND WELDS

Sp 08/10/21

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 08/10/21 (X)

11.0 POWDER COATING

POWDER COATING



M106442



(3X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8-40

01

OVEN TEMPERATURE: 320 °F

FINISH TIME: 9-10

m-f 08/10/21

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Heb



Comment: INSPECT POWDER COAT

08-10-21

(3X)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42513

Part Number: D33191

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST496

18 08/10/21 13

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/21 13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-21

DART AEROSPACE LTD	Work Order:	42513
Description: Wearplate	Part Number:	D3319-1
Inspection Dwg: D3319	Rev: B	Page 1 of 1

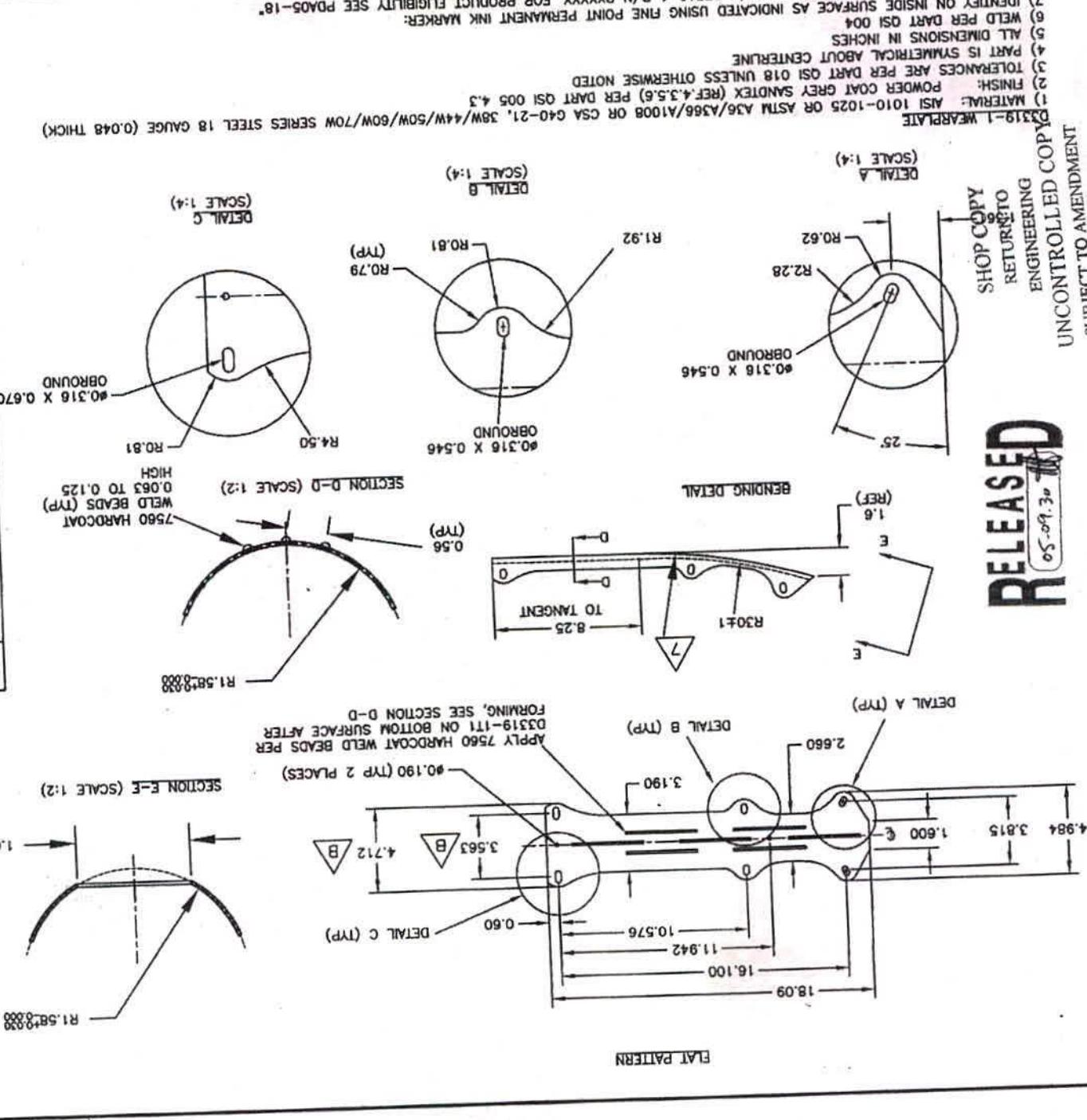
## FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

Measured by:	BS	Audited by:	S	Prototype Approval:	N/A
Date:	8-10-16	Date:	08/10/16	Date:	N/A
Rev	Date	Change		Revised by	Approved
A	07.05.31	New Issue		KJ/JLM	SJ

**DART**

DART AEROSPACE LTD					
HAWKESBURY, ONTARIO, CANADA					
DESIGN	DRAWN BY	APPROVED	DRAWING NO.	SCALE	REV. B
<u>PJ</u>	<u>PJ</u>	<u> </u>	D3319	1:8	SHEET 1 OF 5
CHECKED			TITLE		
			WEARPLATE		
DATE	05.06.06				
A	04.09.24	NEW	ISSUE		
B	05.06.06	WIDEN HOLES,REDUCE	WIDTH -3/-5/-7		



RELEASED  
05-09-30

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